

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013061**Date Inspected:** 16-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bnifacio Daquinag, Tony Sherwood, B. Presch			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS OBG 1W/2W-D		

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 2W/3W-D, 2W/3W-A and the following observations were made:

2W/3W-A

Upon the arrival of the QA Inspector it was randomly observed the ABF welding operators Jordan Hazelaar and Bryce Howell were setting up to continue the submerged arc welding (SAW) fill/cover passes. The QA Inspector noted the SAW fill passes between weld segments A3-A5 appeared to be approximately 80% upon arrival of the QA Inspector. The QA Inspector noted the SAW fill passes between weld segments A3-A1 appeared to be approximately 60% upon arrival of the QA Inspector. The following observations were made:

A3-A5

The QA Inspector randomly observed the ABF welding operator Jordan Hazelaar continue welding the SAW fill/cover passes in the center of A3 and weld to the end of section A5. The QA Inspector randomly observed the SAW parameters and they were 560 Amps, 32.6 Volts and a travel speed of 385mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1. The QA Inspector randomly observed the ABF welding operator complete the above identified weld segments on the QA Inspectors shift. The QA Inspector noted no additional grinding or welding was performed on the QA Inspectors shift.

A3-A1

The QA Inspector randomly observed the ABF welding operator Bryce Howell continue welding the SAW fill

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

passes in the center of A3 and weld to the end of section A1. The QA Inspector randomly observed the SAW parameters and they were 565 Amps, 33.4 Volts and a travel speed of 390mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1. The QA Inspector randomly observed the ABF welding operator continued performing the SAW fill passes for the remainder of the QA Inspectors shift.

2W/3W-D

The QA Inspector performed a random visual inspection of the completed fit up prior to and during the SMAW tack welding of the above identified weld joint. The QA Inspector noted the fit up appeared to be in general compliance with the contract requirements. The QA Inspector noted the ABF welder James Zhen and Chun Fai Tsui were performing the SMAW tack weld full length on both sides of the steel backing bar. The QA Inspector noted the SE QC Inspector Bernard Docena was present at the time of the welding.

Summary of Conversations:

The QA Inspector was present at meeting with the ABF Project Director Brian Peterson, ABF Engineer John Callahan, ABF Welding Quality Control Manager (WQCM) Jim Bowers, Karen Wang, Mets Task Lead Bill Levell and Mets Senior Task Lead Patrick Lowry. Mr. Peterson and Mr. Lowry discussed the methods and times in which the planar misalignment at the top deck plate "A" at all transverse field welds will be measured by Caltrans QA and Smith Emery QC. It was discussed and decided the Caltrans QA Inspectors and the Smith Emery QC Inspectors will perform the fit up inspection and measurements together. It was decided by Mr. Peterson and Mr. Lowry as well as the QA Task Lead Inspector Bill Levell, the measurements will be taken by the same means and methods at the same time to allow continuity with the numbers and measurements produced. It was determined the ABF WQCM Jim Bowers would inform the QA Task Lead Bill Levell when the measurements of the fit up and planar misalignment would be performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
